

[Trouble shooting guide for TP ZHFR:](#)

Problem	Cause	Solution
Bad surface finish	<p>Low temperature in barrel and head</p> <p>Melt fracture</p> <p>O/D of extrusion too low</p>	<p>Increase the barrel and head temperatures</p> <p>Use high shear screw</p> <p>Increase the barrel and head temperatures</p> <p>Reduce the Extrusion rate</p> <p>Use lower draw down ratio</p> <p>Reduce the haul off speed</p> <p>Change to smaller die</p>
Die drool	Low molecular weight material exuding during extrusion.	<p>Add 1-2 % process aid</p> <p>Use highly polished die / point</p>
High motor load	<p>Motor rating may not be sufficient</p> <p>Incorrect screw design</p> <p>Head design restrictive</p> <p>Material too stiff</p>	<p>Increase the motor rating</p> <p>Use lower shear / compression design</p> <p>Change the head design</p> <p>Increase the temperature profile</p>